



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9711

Job Sheet 205914-A



CONT. 5267946

S# 5250742

Part No: 646.9711

Job Qty: 32 pcs

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/1/20

Job Tracking No:

Due Date: 4/27/20

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG 646.9700 REV.H IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
150	Packaging 2-1 - Receive - B4B	32 pcs	4/27/20		0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	
							Packaging 2 - 29 - B4B	
							Packaging 2 - 30 - B4B	
							Packaging 2 - 31 - B4B	
							Packaging 2 - 32 - B4B	
							Packaging 2 - 33 - B4B	



Container No: S267946



Part: 646.9711

Job No: 205914-A

Serial No/Batch: S250742

Revision: Rev H

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
					QC 6 - 9	
155 QC 6	32 pcs	4/25/20	0.00 0.00		QC 6 - 68	DAS
					QC 6 - 61	82
					QC 6 - 40	9-89
					QC 6 - 81	DAS
						APR 0 1 2020
160 Spray Paint - 2 - B4B	32 pcs	4/27/20	0.00 1.07		Spray Paint - 1 - B4B	41 APR 0 5 2020
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
170 QC 14	32 pcs	4/27/20	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	DAS
					QC 14 - 19	82
					QC 14 - 43	9-89
					QC 14 - 24	APR 0 6 2020
					QC 14 - 61	
					QC 14 - 81	QC 14-82
185 Packaging 3-1 - Stock - B4B	32 pcs ✓	4/27/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS
					Packaging 3 - 4 - B4B	CCK 107 80
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	APR 0 7 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
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					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	32 pcs ✓	4/27/20	0.00 0.00	QC 21 - SA - 21 ✓	CCK107
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 150 - (Receive & Inspect for Damage & Mat'l Certs) Descriptions: 155 - (QC6- All purchased or subcontracted products) 160 - (Spray Paint / NDT Room) ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #4 170 - (QC14- Inspect Spray Paint) 185 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Job BOM records could not be found.					
Job Allocations					
Job Allocations could not be found.					

DAS
21APR 07 2020
8:21 AM**Part Specifications**

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.340Inches + 0.000 - 0.005	0.340 0.335		
2	Blade	0.177Inches + 0.005 - 0.001	0.182 0.176		
3	Blade	3.200Inches ± 0.005	3.205 3.195		
4	Blade	0.600Inches ± 0.005	0.605 0.595		
5	Blade	0.985Inches ± 0.005	0.990 0.980		
6	Blade	2.400Inches ± 0.005	2.405 2.395		
7	Blade	1.200Inches ± 0.005	1.205 1.195		
8	Blade	0.250Inches ± 0.005	0.255 0.245		
9	Blade	37.2Angle ± 0.5	37.7 36.7		
10	Blade	0.290Inches ± 0.010	0.300 0.280		
11	Blade	30.0Angle ± 0.5	30.5 29.5		

Plex 4/1/20 8:21 AM dart.leroux.jason



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045772



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045772

PO Date: 2/3/20

Due Date: 2/17/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		646.9711	646.9700 Rev H	Blade : Various STC's (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed X40	-	2/17/20	40 pcs	0 pcs	40 pcs	\$8.375/pcs	\$335.00
Grand Total:												\$335.00

FEB 11 2020

CL



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER

POHB045772



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/6/20 6:50 AM Dart.Lavoie.Chantal

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
342718	1	143476

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
HB045772		A2	2020/2/4	CLIENT

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight

40 646.9711

(40) 646.9711 REV H

11,

1 VALISE

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
VALISE	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40

POIDS EXPÉDIÉ / Weight Shipped : 11,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

FEB 11 2020

DART AEROSPACE LTD.

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 40

POIDS EXPÉDIÉ / Weight Shipped : 11,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2020/02/09

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
342718	1

CLIENT / customer : 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB045772	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

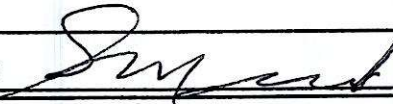
HARDNESS	58 - 62 HRC	DAC 82 9-89	5 (907)	60 - 61 HRC
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QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	11	846.9711 (40) 846.9711 REV H 1 VALISE

18/2/20

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



METCOR
7

DATE: 2020-02-09

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
342718	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB045772	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN		DAS		
		82		
HARDEN AND TEMPER		9-89		
EXIGENCE / requirement	SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed		RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC		5	60 - 61 HRC
			(907)	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	11	646.9711		
		(40) 646.9711		
		DWG 646.9700 REV H		
		1 VALISE		

COMMENTAIRES / comments

VAC HARDEN 1800°F - 1:00 HRE
DOUBLE TEMPER 400°F - 2:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

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Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
342718	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

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APPROUVÉ par / Approved by:

DATE: 2020-02-10

Lucie Desmarais
QA Technician

